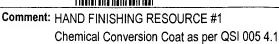
Each

Wednesday, 12/13/2006 2:41:31 PM Date: Kim Johnston **Process Sheet** : STEP LEG Customer : CU-DAR001 Dart Helicopters Services **Drawing Name** Job Number : 29922B : 10353 **Estimate Number** NA **Part Number** : D2278 P.O. Number : D2278 REV E S.O. No. : NIK : 12/13/2006 **Drawing Number** This Issue **Project Number** : N/A Prsht Rev. MA : SMALL/MED FAB ; E First Issue Type **Drawing Revision** :NIA: : 29846 Material **Previous Run** : 1/5/2007 **Due Date** Qty: 40 Um: Written By **Checked & Approved By** 05-11-07 JLM Comment : Est Rev:A New Issue Est Rev:B Now 6061-T6 06-06-23 JLM **Additional Product** Job Number: Description: Seq. #: 1.0 M6061T6S080 6061-T6 .080 Sheet Comment: Qty.: 1.0306 sf(s)/Unit Total: 41.2230 sf(s) 11.3366 Material: 6061-T6 sheet (QQ-A-250/8) 0.080" Thick (M6061T62S.080) M103713 Identify as D2278 Batch: <u>M1034</u>34 2.0 WATER JET Comment: FLOW WATER JET 1-Cut as per Dwg D2278 Dwg Rev: E Prog Rev: E 2-Deburr if necessary 3.0 QC2 Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK 4.0 QC8

Comment: SECOND CHECK HAND FINISHING1 5.0

HAND FINISHING RESOURCE #1



		WORK ORDER CHANGES									
DATE	STEP		PROCEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
		·			9						
				93							
							`		ā e		
_			*		Fr :		,				
art No:		DAE	# Foult Co		N/A	D. Van	(i) po	4) 5	- 1-1-X	

Part No:	_ PAR #:	Fault Category: _	NCR: Yes (No)	DQA:	Date: <u>07/63/88</u>
			QA: N/C C	losed:	Date:

NCR:		•	DER NON-CONFORMAN	CE (NCR)				
		Description of NC		Corrective Action Section E		Verification	Approval	
DATE STI	STEP	Section A	Initial Action Description Chief Eng Chief Eng		Sign & Date	Sign & Section C		Approval QC Inspector
						340		
				1.7				
<u></u>								
i								

NOTE: Date & initial all entries

Wednesday, 12/13/2006 2:41:32 PM Date: User: Kim Johnston **Process Sheet** Drawing Name: STEP LEG Customer: CU-DAR001 Dart Helicopters Services Job Number: 29922B Part Number: D2278 Job Number: Seq. #: Description: **Machine Or Operation:** INSPECT POWDER COAT/CHEMICAL CONVERSION 6.0 QC3 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PACKAGING RESOURCE #1 7.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location:_ QC21 8.0 Comment: FINAL INSPECTION/W/O RELEASE U 07-03.20 Job Completion

Dart Aerospace Ltd

W/O: DATE STEP PROCEDURE CHANGE By Date Qty Approval Chief Eng / Prod Mgr Prod Mgr QC Inspection Approval Chief Eng / Prod Mgr QC Inspection Approval Chief Eng / Prod Mgr Approval Ch								
DATE STEP		PROCEDURE CHANGE	Ву	Date	Qty	Chief Eng /	Approval QC Inspector	
	:							
Part No.		DAP #: Foult Cotogony		NCD: Voc	No DO		Data	

Part No: _		PAR #:	Fault Category:	NCR: Yes No	DQA:	Date: _	
				QA: N/C C	losed:	Date: _	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B	Verification		Approval				
DATE	Section A Initial Action De		Action Description Chief Eng	Sign & Section C		Approval Chief Eng	Approval QC Inspector				
)			= 7					
			¥ -								
							i i più				

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	2992215
Description: Leg	Part Number:	D2278
Inspection Dwg: D2278 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
---	---------------	--	-----------

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments	
0.354	+/-0.010	6.350	_		Vern		
0.354	+/-0.010	0.351	1		Vern		
2.250	,+/-0.005	2.247	/		Vern		
16.458	+/-0.010	16.450	/		H-T/vern		
Ø0.128	+0.005/-0.000	Ø0.130	V		Vern		
R0.354	+/-0.010	RO.354	/		R-6		
2.000	+/-0.010	2,007	7		Very		
4.736	+/-0.010	4.734	/		Very		
8.325	+/-0.010	8.327	W		Vern		
Ø0.213	+0.005/-0.000	Ø0.213	/		Veru		
0.080 thick	+/-0.010	0.079	/		Vern		
					, , , , , , , , , , , , , , , , , , , ,		

Measured by: SAD	Audited by:	Prototype Approval:	N/A
Date: 07/03/04	Date: 07/03/08	Date:	N/A

Rev	Date	Change		Revised by	Approved
Α	04.10.12	New Issue	P/O D2582	KJ/JLM	
В	06.03.08	Dwg Rev. changed		KJ/JLM LA	21
С	06.06.23	Dwg Rev. changed		KJ/JLM of	

9,00 D2278 LEG MATERIAL: 0.000 MOLICE 0.354 DIMENSIONS ARE IN INCHES TOLERANCES **AMENDATENT** LE OLLED COPY . - SINEERING **TETURN TO** SHOP COPY AMS 2.604 ACID ETCH AND ALODINE PER DART QSI 005 4.1 0.080" THICK (REF DART SPEC M5052H32S.080) 5052-H32 ALUMINUM SHEET (PER QQ-A-250/8 6061-T6 ALUMINUM SHEET ARE PER DART Ø0,213 R0,354 4027) 0.080" **GRAIN** 4.126 R1,000 DIRECTION 4.885 - 5.239 4.854 7.169-0 5.647 QSI 018 2,000-THICK (REF DART SPEC M6061T6S.080) 6.428 7,104 7.193 7.311 7.966 UNLESS OTHERWISE NOTED 8.093-⊕ (PER QQ-A-250/11 OR AMS 8.238 8.578-0 6.284 4,361 9.354 9.782-0 4.361-10.986-0 11.604 -11.745 RELEASE 2.375-12.190 OR AMS 4016) 36 12.940 R0.354 13,205 13,438 13.854 13.936 4025 R0.375 (TYP) 14.433 16,104 16,458 Ø0.128 (TYP) 9T-1909 GGA **MATERIAL** 62.20.90 Э **LINISHING NOTE QQA** 41.11.80 a CHANGED RADIUS TO 91,20,36 Э 2.2:1 TEC 62.20.90 3JIII SCALE DATE SHEET 1 OF 1 D2278 HS DRAWING NO. CHECKED REV. E. немкезвиву, оитавіо, самара CB BM DART AEROSPACE LTD DRAWN BY DESIGN

COPYIGNE ON THE DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

